

Work Order ID 118420

Thursday, July 17, 2014 9:50:51 AM

118420

Page 1

Item ID: D412-704-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Co-Pilot Emergency Cargo Release

Start Date: 6/26/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/27/14 Req'd Qty: 1.00 ***1***

Customer: CWILD02

Reference: RMA RA111620

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D412-704	C

100

0.00

100

QC

Quality Control

Memo

0.00

INSPECT RA 111620
D412-704-011 X 1 B102032

KIT IS MISSING

D3208-7 X 1 B 101715D3207-11 X1 B 101650MS21919-DG5 X4 B 128401

ID AND STOCK UNDER NEW BATCH NUMBER

ADD PAPERWORK

CUSTOMER RETURNED IN KIT D4610-1 X 1 B103804 (DOESN'T GO IN
KIT SO PLACE BACK INTO STOCK UNDER ORIGINAL BATCH
NUMBER)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 118420

Thursday, July 17, 2014 9:50:52 AM

118420

Page 2

Item ID: D412-704-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Co-Pilot Emergency Cargo Release

Stop

NS2

Start Date: 6/26/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/27/14 Req'd Qty: 1.00

1

Customer: CWILD02

Reference: RMA RA111620

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00

110

Packaging

Memo

0.00

Packaging

FG018

g.B ~~14-07-22~~

DAS
31
9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

JUL 24 2014

DAS
06
9-89

Packing

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MLJ 14-07-24

14-7-24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Thursday, July 17, 2014 9:50:58 AM

118420

D412-704-011

Required Date: 6/27/14

Required Qty: 1.00

Comments: IPP Rev:B05.01.28Hardware added to Step 3KJ/RF
IPP Rev:C05.12.21Hardware removed on Step 3 EC IPP REV:D AS
PER REV C JLM VERIFIED BY:EC
IPP REV:E 12.05.10 per ECN 12-583 DD verf:EC

[illegible]

✓ x 10 20 32
mf
14-7-23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Thursday, July 17, 2014 9:50:58 AM

Page 2

Work Order ID: 118420

118420

Parent Item: D412-704-011

D412-704-011

Parent Item Name: Co-Pilot Emergency Cargo Release

Start Date: 6/26/14

Required Date: 6/27/14

Start Qty: 1.00

Required Qty: 1.00

D4610-1

Manufactured No

Each 2.0000 -1

D4610-1

Doubler

**

DAS

33

9-89

Location

Loc Qty

Loc Code

ST110

2

103804

1

104412

1

Each

66.0000

**

4

DAS

33

9-89

14-07-22

MS21919-DG5

Purchased No

MS21919-DG5

Clamp

Location

Loc Qty

Loc Code

ST300

66

110916

2

m128401

9

m128813

25

m129499

30

128401

DAS

31

9-89

DAS
06
9-89

Thursday, July 17, 2014 9:50:58 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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RA 111620 D412-704-011

B102032

Received @ Dart October 1st, 2013
Inspected @ Dart June 26th, 2014

CUSTOMER: WILDCAT HELICOPTERS
CUSTOMER CONTACT: PATRICK RENAUD
SHIPPED FROM:???

Instructions for RA 111620 D412-704-011 B102032 CHG003

- Kit missing D3208-7 B97596
- Customer returned in kit D4610-1 B103804
- Return all parts to stores under all original Batch #'s
 - D412-704-041 B102231 x1
 - D412-704-045 B102033 x1
 - D3207-5 B85999 x1
 - D3207-7 B100791 x1
 - D3207-11 B97959 x1
 - D3208-1 B105253 x1
 - D3208-11 B95507 x1
 - D3208-3 B97596 x1
 - D3208-9 B88584 x1
 - D3214-1 B103591 x1
 - D4610-1 B103804 x1
 - MS21919-DG5 M125807 x4

Time Estimate = 1 HOUR

Departments Required: Stores

Pictures Attached = N/A

Current CHG # 003

QTY INSPECTED = x1 D412-704-011 B102032

**THIS INSTRUCTION SHEET MUST
BE ATTACHED TO THE
RESTOCKING WORK ORDER AT
ALL TIMES!!!!**

DQA: _____ Date: _____



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Material									
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Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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